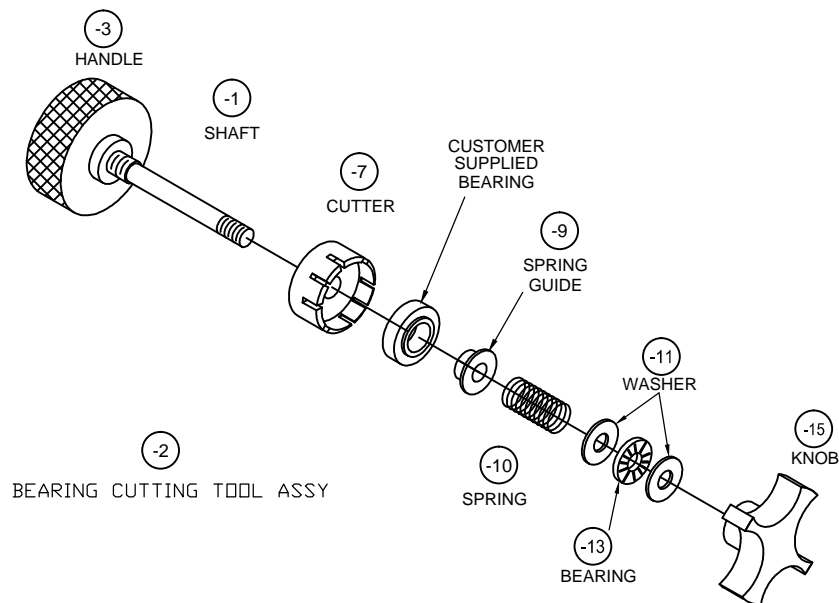
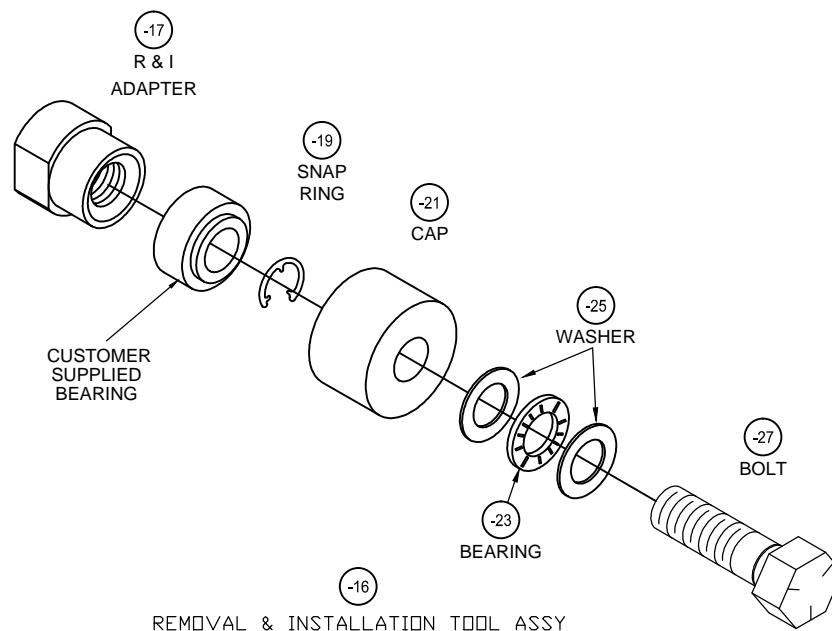


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NOTE:
BEARING #206-031-594-003, ASTRO NHW7V203 J/N 39034-2 AD

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/04		
2	CH'D -27 GROOVE FOR RETAINING RING.	9/21/06		
3	CH'D -7 PREGRIND TOLERANCE FROM .940 +.005 -.002.	1/2/08	WP	G.E.
4	ADDED AN 8° HOOK TO CUTTING TEETH, WAS STRAIGHT WITH NO HOOK.	1/29/08	WP	DW
4A	CH'D TITLEBLOCK & REVISION BLOCK, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/29/09	RJC	RW

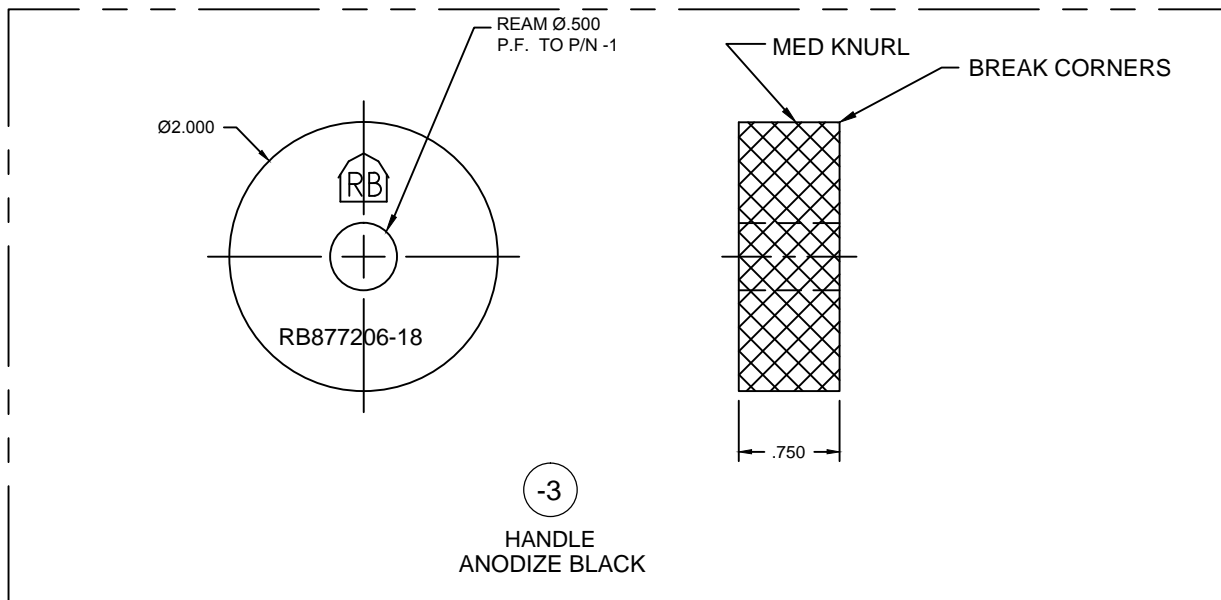
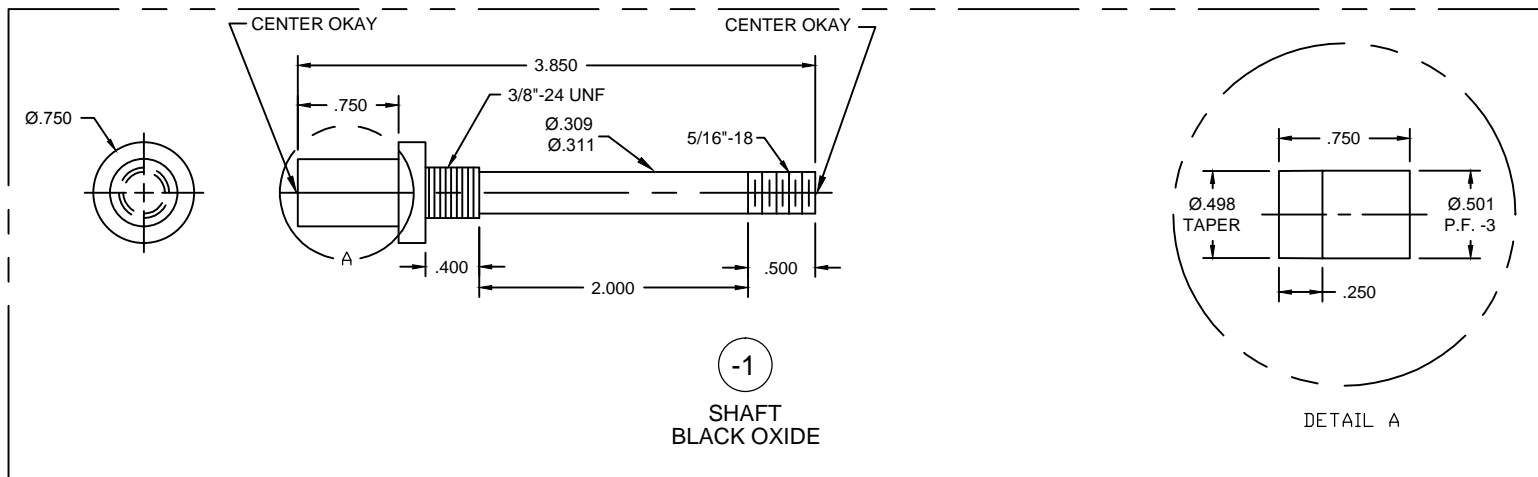


ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
	1		-1		SHAFT	STRESS PROOF	Ø3/4 x 4	2
	1		-2	1	BEARING CUTTER TOOL ASSY			1
	1		-3		HANDLE	6061 T6	Ø2 x 3/4	2
	1		-7		CUTTER	01	Ø1 x 5/8	3
	1		-9		SPRING GUIDE	STRESS PROOF	Ø5/8 x 5/16	3
	1	B/O	-10		SPRING	-	5/16 x 2 (EUGENE FASTNER #16)	1
	2	B/O	-11		WASHER	-	TRA-411 (APPLIED INDUSTRIAL)	1
	1	B/O	-13		BEARING	-	NTA-411 (APPLIED INDUSTRIAL)	1
	1	B/O	-15		KNOB	-	DK-54 (REID TOOL)	1
	1		-16	1	REMOVAL & INSTALLATION TOOL ASSY			1
	1		-17		R&I ADAPTER	STRESS PROOF	Ø1 x 1-1/4	4
	1	B/O	-19		RETAINING RING	-	Ø3/8 EXTERNAL E-37	1
	1		-21		CAP	6061 T6	Ø1-1/4 x 1	4
	1	B/O	-23		BEARING	-	NTA-613 (APPLIED INDUSTRIAL)	1
	2	B/O	-25		WASHER	-	TRA-613 (APPLIED INDUSTRIAL)	1
	1		-27		BOLT	GRADE 5	7/16-20 UNF x 2-1/2 MODIFY	4

RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-18	REV 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-28-01
SHEET 1 of 4	

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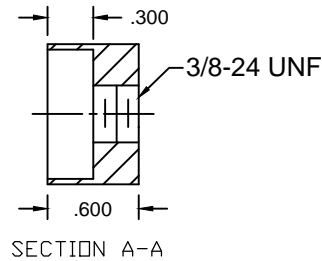
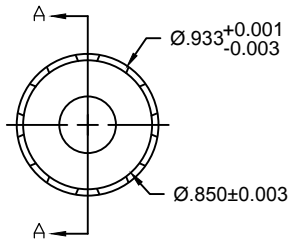
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
4A	CH'D TITLEBLOCK & REVISION BLOCK, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/29/09	RJC	-



RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-18-1 & -3	REV 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
.XXX ± .005	ANGLES ± 5°
.XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-28-01
SHEET 2 of 4	

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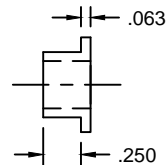
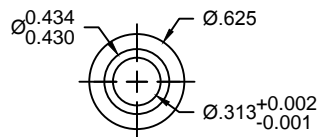
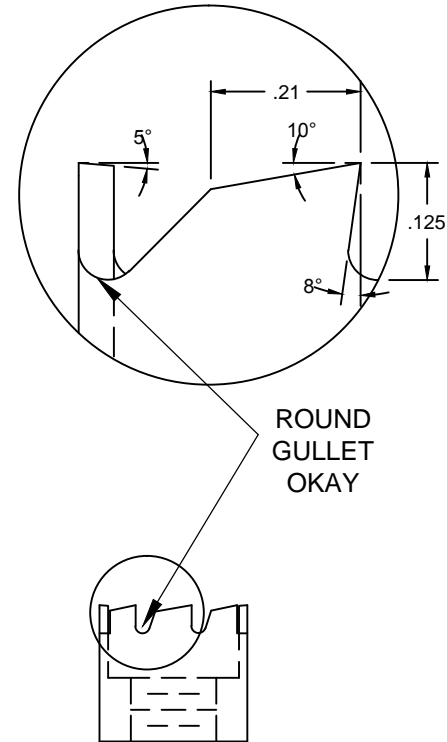
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/04		
3	CH'D -7 PREGRIND TOLERANCE FROM .940 +.005 -.002.	1/2/08	WP	G.E.
4	ADDED AN 8° HOOK TO CUTTING TEETH, WAS STRAIGHT WITH NO HOOK.	1/29/08	WP	DW



-7

CUTTER
8 TEETH
HEAT TREAT: 50-60 Rc
NO OXIDE COATING

MACHINE TO $.953^{+.005}_{-.000}$
GRIND TO SIZE
AFTER HEAT TREAT



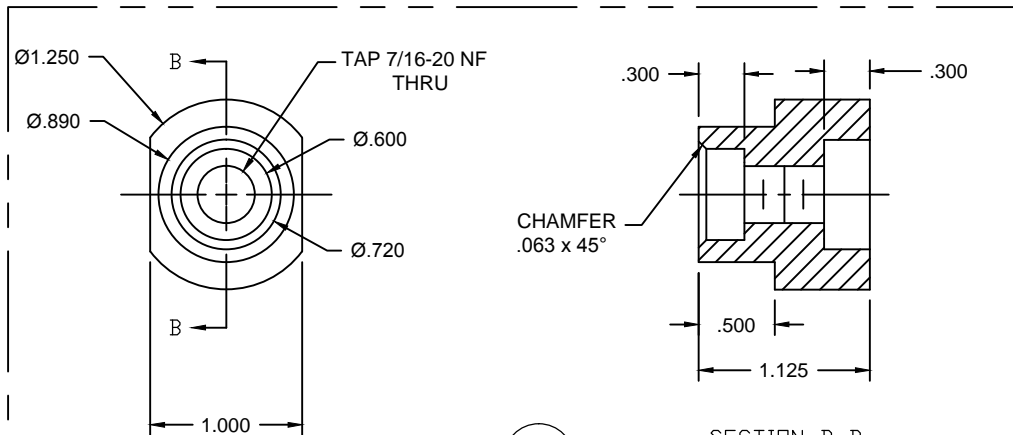
-9

SPRING GUIDE
BLACK OXIDE

RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-18-7 & -9	REV 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-28-01
SHEET 3 of 4	
DRAWN BY: COLE	
APPROVED	
HEAT TREAT SEE PART	
FINISH SPEC SEE PART	
USED ON MODEL BELL	

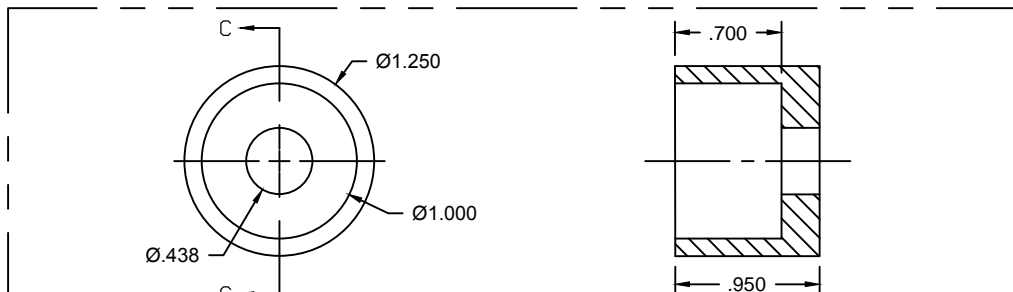
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
2	CH'D -27 GROOVE FOR RETAINING RING.	9/21/06	



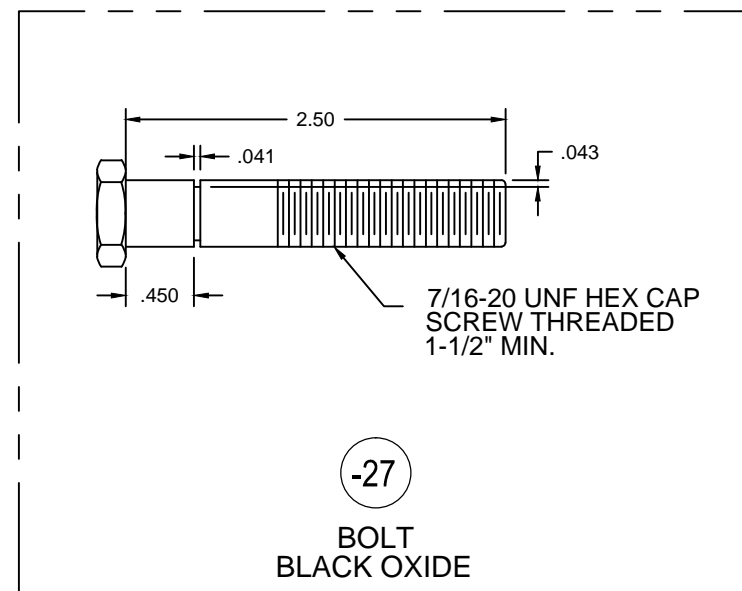
-17

ADAPTER R&I
BLACK OXIDE



-21

CAP
ANODIZE BLACK



-27

BOLT
BLACK OXIDE

RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-18-17 thru -27	REV 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: COLE APPROVED HEAT TREAT FINISH SPEC SEE PART USED ON MODEL BELL
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.15 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-28-01
SHEET 4 of 4	

